



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D350-591-412
Job Sheet 196085



Part No: D350-591-412

Job Qty: 5 pcs

Part Name: AS350/355 Heli-Access-Step - RH, DART Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/5/19

Job Tracking No:

Due Date: 7/5/19 *July 20*

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV.B 18/08/02 AS PER IIN REV:I JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	5 pcs	7/5/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		<i>Oscar</i>
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		<i>PC</i>
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: S205916



Part: D350-591-412

Job No: 196085

Serial No/Batch: S205916

Revision: I

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 19

				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
115	Packaging 1-1 - Pick Kit - B4B 5 pcs	7/5/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
120	QC 4 5 pcs	7/5/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
130	DC - 1 - B4B 5 pcs	7/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
140	Packaging 3-1 - Stock - B4B 5 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	

WayB

8/16/2019

DAS
75
9-89

8/16/2019

DAS
21
9-89

AUG 16 2019

DAS
75
9-89

8/16/2019

					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - FG	5 pcs	7/5/19	0.00 0.00	QC 21 - FG - 21	DAG
					QC 21 - FG - 70	21
					QC 21 - FG - 53	9-55
Part Op 110 - Pick Kit						
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)						
130 - Photocopy bluefile & type labels per PPP D350-591-411 CHG001						
140 - Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D350-591-411						
150 - (QC21- Final Inspection - Work Order Release)						

AUG 16 2019

011269

5192159 X5

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-36A	Bolt	14 10 Ea (2 ea)	110-Packaging 1 - Pick Kit	FM133011 X5 515260 X4
AN310-4	Nut	7 5 Ea (1 ea)	110-Packaging 1 - Pick Kit	5181800
AN4-11A	Bolt	14 10 Ea (2 ea)	110-Packaging 1 - Pick Kit	51747816
AN4-12	Bolt	7 5 Ea (1 ea)	110-Packaging 1 - Pick Kit	5193112
AN4-14A	Bolt	28 20 Ea (4 ea)	110-Packaging 1 - Pick Kit	5199606
D2230-1	Mounting Lug	14 10 pcs (2 ea)	110-Packaging 1 - Pick Kit	51723726 5129816 X8
D2230-3	Mounting Lug	14 10 pcs (2 ea)	110-Packaging 1 - Pick Kit	5187436
D2690-11	Lanyard Assembly	7 5 pcs (1 ea)	110-Packaging 1 - Pick Kit	5195280
D2732-030	Rubber Cushion - 3"	28 20 pcs (4 ea)	110-Packaging 1 - Pick Kit	5186742
D5491-042	Step Assembly	7 5 pcs (1 ea)	110-Packaging 1 - Pick Kit	5199494
D5494-041	Front Step Leg Assembly	7 5 pcs (1 ea)	110-Packaging 1 - Pick Kit	5203528
D5495-041	Front Skidtube Spacer Assembly	7 5 pcs (1 ea)	110-Packaging 1 - Pick Kit	5194609
D5496-1	Connector	7 5 pcs (1 ea)	110-Packaging 1 - Pick Kit	5203669
D5651-1	Washer	14 10 pcs (2 ea)	110-Packaging 1 - Pick Kit	5189323
MS20600AD4W4	Rivet	70 50 Ea (10 ea)	110-Packaging 1 - Pick Kit	5191278
MS21042L3	Nut	21 15 Ea (3 ea)	110-Packaging 1 - Pick Kit	5149299
MS21042L4	Nut	41 30 Ea (6 ea)	110-Packaging 1 - Pick Kit	5202668
MS24665-151	Cotter Pin	7 5 Ea (1 ea)	110-Packaging 1 - Pick Kit	5144755
MS27039-1-07	Screw	7 5 Ea (1 ea)	110-Packaging 1 - Pick Kit	511086
NAS1149D0332J	Washer	21 15 Ea (3 ea)	110-Packaging 1 - Pick Kit	5113751
NAS1149D0363J	Washer	28 20 Ea (4 ea)	110-Packaging 1 - Pick Kit	5191231
NAS1149D0463J	Washer	98 70 Ea (14 ea)	110-Packaging 1 - Pick Kit	5200189

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-36A	10	59	0
	AN310-4	5	117	0
	AN4-11A	10	122	0
	AN4-12	5	61	0
	AN4-14A	20	450	0
	D2230-1	10	190	0
	D2230-3	10	437	0
	D2690-11	5	0	0
	D2732-030	20	411	0
	D5491-042	5	0	0
	D5494-041	5	6	0
	D5495-041	5	1	0
	D5496-1	5	12	0
	D5651-1	10	8	0
	MS20600AD4W4	50	100	0
	MS21042L3	15	1,814	0
	MS21042L4	30	1,976	0
	MS24665-151	5	356	0
	MS27039-1-07	5	80	0
	NAS1149D0332J	15	3,440	0
	NAS1149D0363J	20	1,354	0
	NAS1149D0463J	70	3,131	0

Part Specifications

Specifications could not be found.

Plex 6/5/19 3:23 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			

Qty -411	Qty -412	Part Number	Description
X		D350-591-411	<i>Hell-Access-Step™</i> , DART Float Compatible – High Skid, LH
	X	D350-591-412	<i>Hell-Access-Step™</i> , DART Float Compatible – High Skid, RH
2	2	D2230-1	MOUNTING LUG
2	2	D2230-3	MOUNTING LUG
1	1	D2690-11	LANYARD
4	4	D2732-030	RUBBER CUSHION
1		D5491-041	STEP ASSEMBLY, LH
	1	D5491-042	STEP ASSEMBLY, RH
1	1	D5496-1	CONNECTOR
1	1	D5494-041	FRONT STEP LEG ASSY
1	1	D5495-041	FRONT SKIDTUBE SPACER
2	2	D5651-1	WASHER
2	2	AN3-36A	BOLT
4	4	AN4-14A	BOLT
1	1	AN4-12	BOLT
2	2	AN4-11A	BOLT
1	1	AN310-4	NUT
10	10	MS20600AD4W4	RIVET
3	3	MS21042L3	NUT
6	6	MS21042L4	NUT
1	1	MS24665-151	COTTER PIN
1	1	MS27039-1-07	SCREW
3	3	NAS1149D0332J	WASHER
4	4	NAS1149D0363J	WASHER
14	14	NAS1149D0463J	WASHER

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Revision: I

Date: 18.05.25

Change Record

PAGE 1 OF 1

Part Number: D350-591-411/-412

Description: HELI-ACCESS STEP, DART FLOAT COMPATIBLE, HIGH SKID, LH/RH

[illegible]

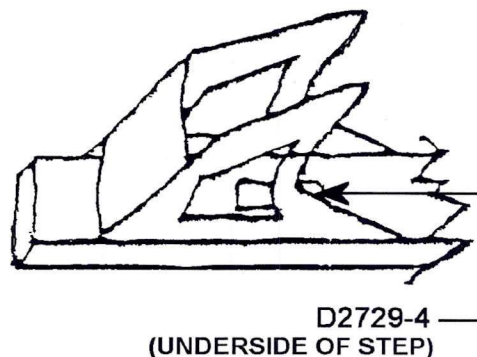
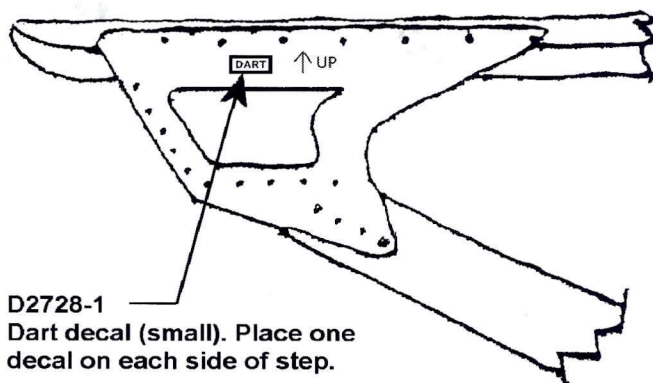
Part Number	D350-591-111A
Description	Heli-Access Step, High

Box Part Number	MBX104	Dimension	121 x 13 x 7
Other Packaging	MF1612		MF4612B
Logo Decals	D2728-1		

Packaging Instructions and Decal Placement

D350-591-111A

Apply label D2729-4 & D2728-1 as per drawing below and ensure Dart label is facing up. Place step in plastic bag. Place MF1612 at each end of box and glue to the interior. Place 4 pcs of MF4612B evenly spaced out in bottom of box. Place step in box, apply top portions of MF4612B to correspond with bottom foam already in place. Place hardware and paperwork in plastic bag, then place packages at end of step, ensure hardware and paper work tightly package between end of box and MF4612B. To prevent movement apply glue to the top pieces of MF4612B. Close box, apply Dart logo tape (Always starting at first complete Dart logo) on front flap of box, length wise. Apply strapping after first Dart logo there after applying strapping after every second Dart logo, apply clear tape over strapping. Apply label D2729-3 as per instructions in QSI 014.



D2729-4

D2729-3

1270 ABERDEEN ST. HAWKESBURY ON CANADA K6A 1K7 TEL: 1-613-632-5200 www.dartaerospace.com			
PATENT	N/A	CHG	CHG005
P/N	D350-591-111A	STC	SH92-6
DESC.	Heli-Access Step, High	STC	SH967NE
LOT	BXXXXXX	STC	
MODEL	AS350/355	STC	
TC APPROVAL # 09-89		MADE IN CANADA	

		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200
HELI-ACCESS STEP, HIGH		
P/N: D350-591-111A		CHG005
B/N: BXXXXXX		

Revision: K
Date: 15.12.04